

Work Order ID 83535

83535

Page 1

April-19-12 11:22:43 AM

Item ID: D4435-045

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: T/R Bellcrank Cover Assembly

Start Date: 19/04/2012 Start Qty: ~~5.00~~ ⁶

5

Cust Item ID:

Required Date: 03/05/2012 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/04/19

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4435

B

100

0.00

100

Small Fab

Memo

0.00

Small Fab

Assemble as per dwg

6

Ø

FF
12-08-31

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

SMB
128.31

DAS
16
0-8

17642/31

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 83535

83535

Page 2

April-19-12 11:22:43 AM

Item ID: D4435-045

Accept

N9000040100

Setup Start

NS1

Revision ID:

Item Name: T/R Bellcrank Cover Assembly

Stop

NS2

Start Date: 19/04/2012 Start Qty: 5.00

5

Cust Item ID:

Required Date: 03/05/2012 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

120

Powdercoat

Memo

0.00

Powder Coating

*** MASK NUT PLATE HOLES ***

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

2:45
320°F
3:15

130

QC3- Inspect Part Finish

0.00

130

QC

Memo

0.00

Quality Control

140

Identify as per dwg & Stock Location: 273

0.00

140

Packaging

Memo

0.00

Packaging

6X ~~φ~~ M.F. 12/09/04

6 ~~φ~~ Bk 12-9-4.

6 ~~φ~~ / 8 12/9/05

M121279

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 83535

83535


Page 3

April-19-12 11:22:43 AM

Item ID: D4435-045 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: T/R Bellcrank Cover Assembly
 Start Date: 19/04/2012 Start Qty: 5.00 ***5*** Cust Item ID:
 Required Date: 03/05/2012 Req'd Qty: 5.00 ***5*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									

12/9/5 

12-09-5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-19-12 11:22:48 AM

Page 1

Work Order ID: 83535

83535

Parent Item: D4435-045

D4435-045

Parent Item Name: T/R Bellcrank Cover Assembly

Start Date: 19/04/2012

Required Date: 03/05/2012

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP RevB 11.12.22 per PA2 EC verified by:JLM IPP RevC
12.01.23 per REVA DD verified by:EC IPP REV:D 12.03.06
AS PER DWG REV.B DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4435-5		Manufactured	No			100	Each	3.0000	1	5			
D4435-5									**			(6) FF 12-08-31	
Mount Bracket													

Location	Loc Qty	Loc Code
ENG 85840	-2	6
74754	2	
77911	1	
ST236B	5	

D4435-7		Manufactured	No			100	Each	1.0000	1	5			
D4435-7									**			(6) FF 12-08-31	
Bracket													

Location	Loc Qty	Loc Code
GA 83536	1	6
80652	1	

MS20426AD3-2	3	Purchased	No			100	Each	18,319.00	4	20			
MS20426AD3-2									**			(6) FF 12-08-31	
Rivet													

Location	Loc Qty	Loc Code
Mezz 122814	18319	24
1173	8919	
13276	9400	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-19-12 11:22:48 AM

Page 2

Work Order ID: 83535

83535

Parent Item: D4435-045

D4435-045

Parent Item Name: T/R Bellcrank Cover Assembly

Start Date: 19/04/2012

Required Date: 03/05/2012

Start Qty: 5.00

Required Qty: 5.00

MS20470AD4-3

Purchased

No

100

Each

5,495.000

4

20

MS20470AD4-3

Rivet - Universal Head

**

⑥ FF 12-08-31

Location

Loc Qty

Loc Code

Mezz

5495

1642

861

2193

4634

24

MS21059L3

Purchased

No

100

Each

207.0000

1

5

MS21059L3

Nut Plate

**

⑥ FF 12-08-31

Location

Loc Qty

Loc Code

302

122 452

100

121185

100

ST301

28

118614

8

119546

20

ST302

79

120308

13

120833

1

121011

65

6

MS21062L3

Purchased

No

100

Each

67.0000

1

5

MS21062L3

Nut Plate

**

⑥ FF 12-08-31

Location

Loc Qty

Loc Code

ST302

17

120478

17

ST303

50

120930

50

6

April-19-12 11:22:48 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

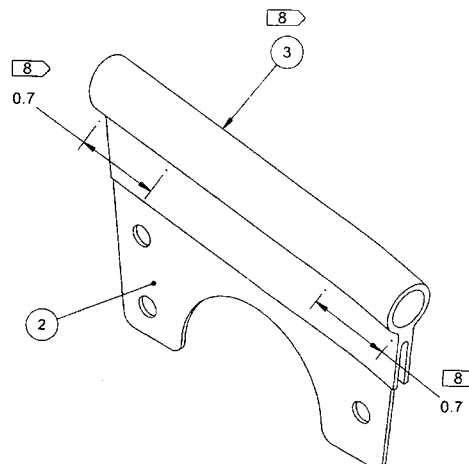
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D4435-041	BRACKET ASSEMBLY
2	1	D4435-1	BRACKET
3	1	D4441-1-035	RUBBER SEAL
4	A/R	3M 1300/1300L	ADHESIVE



D4435-041 BRACKET ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.04 lbs
- 8) GLUE RUBBER SEAL TO BRACKET EDGE USING 3M 1300/1300L ADHESIVE, EXCEPT 0.7" FROM EACH END. ENSURE BRACKET IS COMPLETELY INSERTED INTO GROOVE OF RUBBER SEAL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER

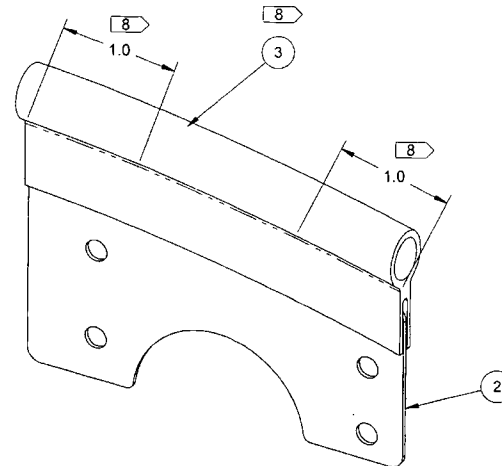
NO. 83535 MJS
12/04/19

RELEASED
2012-03-02

B	ADD A HOLE TO D4435-9F (ZN C7-11)	RF	12.01.27
A	NEW ISSUE	RF	12.01.17
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>RF</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>RF</i>	D4435	SHEET 1 OF 11
APPROVED	<i>RF</i>	TITLE	SCALE
DE APPR.	<i>RF</i>	BRACKET	NTS
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ITEM	QTY -043	PART NUMBER	DESCRIPTION
1	X	D4435-043	MOUNT BRACKET ASSEMBLY
2	1	D4435-3	BRACKET
3	1	D4441-1-037	RUBBER SEAL
4	A/R	3M 1300/1300L	ADHESIVE

83535



D4435-043 BRACKET ASSEMBLY

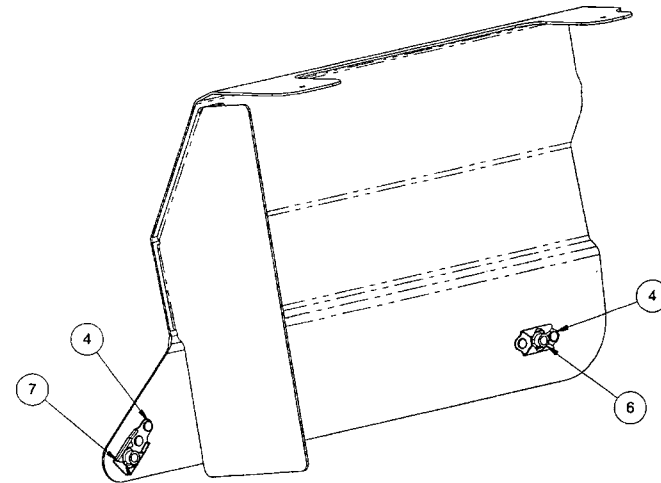
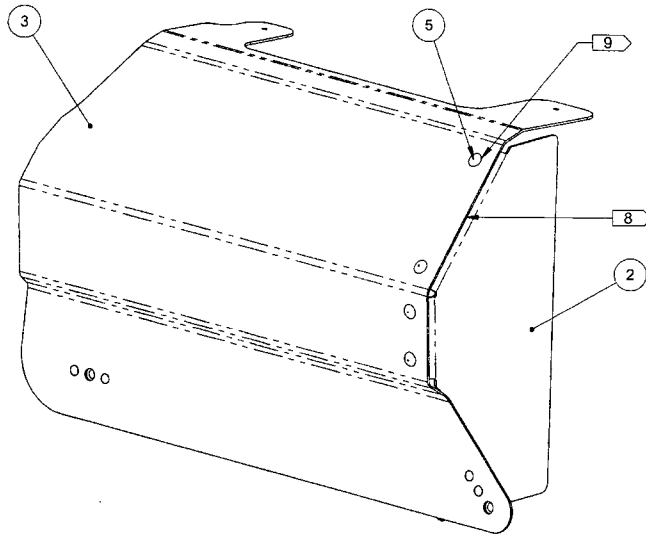
RELEASED
2012-03-02
JW

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.04 lbs
- 8) GLUE RUBBER SEAL TO BRACKET EDGE USING 3M 1300/1300L ADHESIVE, EXCEPT 1.0" FROM EACH END. ENSURE BRACKET IS COMPLETELY INSERTED INTO GROOVE OF RUBBER SEAL

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	140	DRAWING NO.	REV. B
MFG. APPR.	EE	D4435	SHEET 2 OF 11
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ITEM	QTY -045	PART NUMBER	DESCRIPTION
1	X	D4435-045	T/R BELLCRANK COVER ASSEMBLY
2	1	D4435-5	MOUNT BRACKET
3	1	D4435-7	BRACKET
4	4	MS20426AD3-2	RIVET
5	4	MS20470AD4-3	RIVET
6	1	MS21059L3	NUT PLATE
7	1	MS21062L3	NUT PLATE



83535

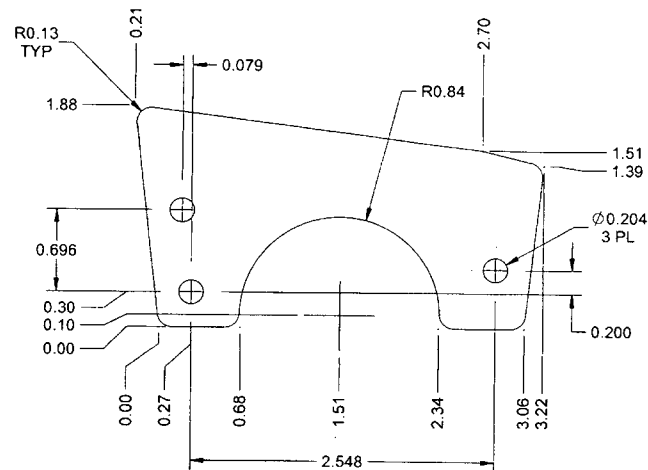
D4435-045 T/R BELLCRANK COVER ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.371 lbs
- 8) INSTALL D4435-5 BRACKET SURFACE FLUSH WITH THIS EDGE
- 9) TRANSFER Ø0.129 HOLES FROM D4435-5 MOUNT BRACKET INTO D4435-7 BRACKET

RELEASED
2012-03-02
JMO

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	140	DRAWING NO.	REV. B
MFG. APPR.	E	D4435	SHEET 3 OF 11
APPROVED	140	TITLE	SCALE
DE APPR.	140	BRACKET	NTS
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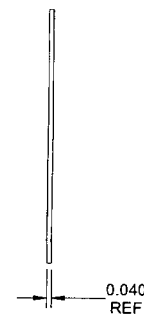
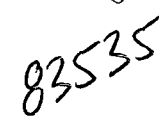
D4435-1 BRACKET

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC. M6061T6S.040
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs

RELEASED
2012-03-02
JW

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>RF</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>RF</i>	D4435	SHEET 4 OF 11
APPROVED	<i>RF</i>	TITLE	SCALE
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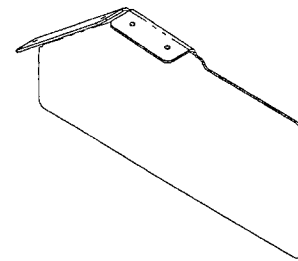
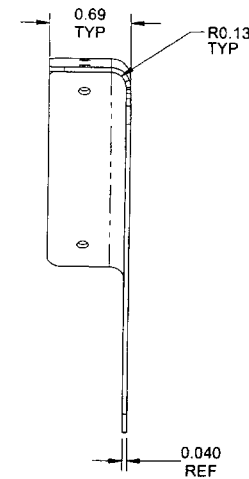
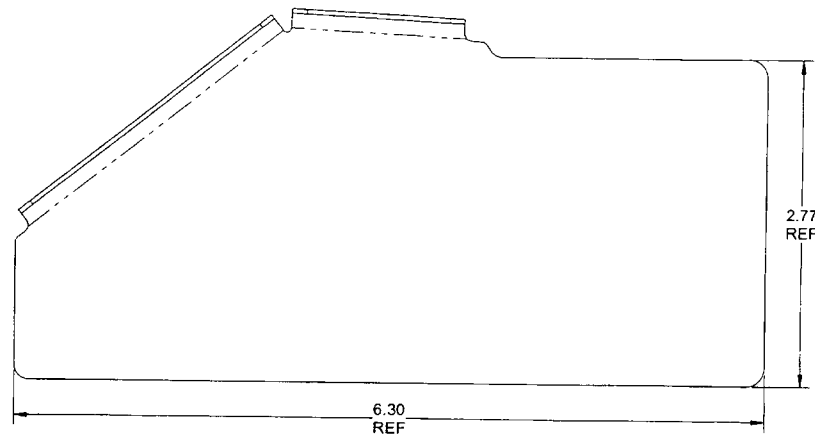
2012-03-02

D4435-3 BRACKET

NOTES:

- NOTES:**
- 1) MATERIAL: 6061-T6T62 ALUMINUM SHEET 0.040 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC. M6061T6S.040
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "BLACK SANDEX" (4.3.5.7) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.023 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>RF</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>RF</i>	D4435	SHEET 5 OF 11
APPROVED	<i>RF</i>	TITLE	SCALE
DE APPR.	<i>RF</i>	BRACKET	NTS
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D4435-5 MOUNT BRACKET

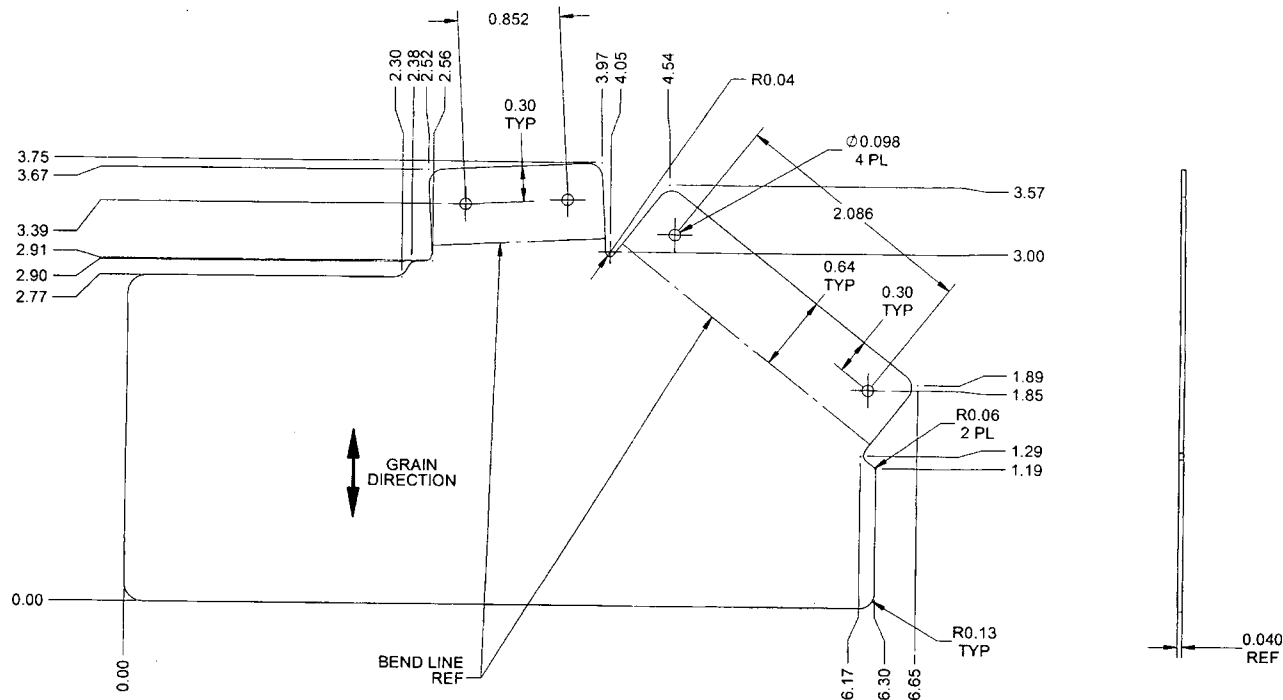
RELEASED
2012-03-02

NOTES:

- 1) MATERIAL: MAKE FROM D4435-5F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	160	DRAWING NO.	REV. B
MFG. APPR.	EE	D4435	SHEET 6 OF 11
APPROVED	160	TITLE	SCALE
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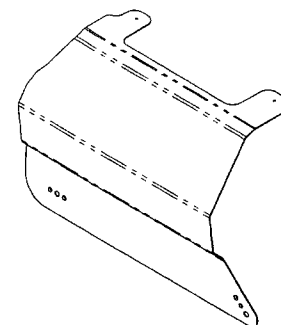
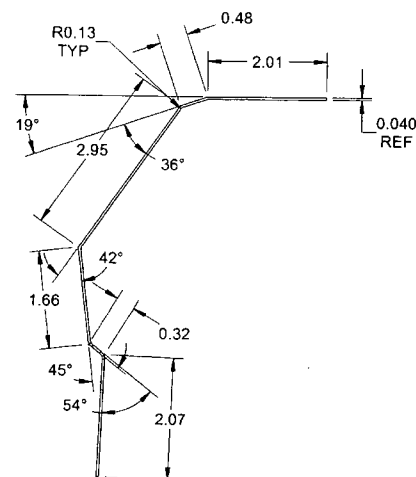
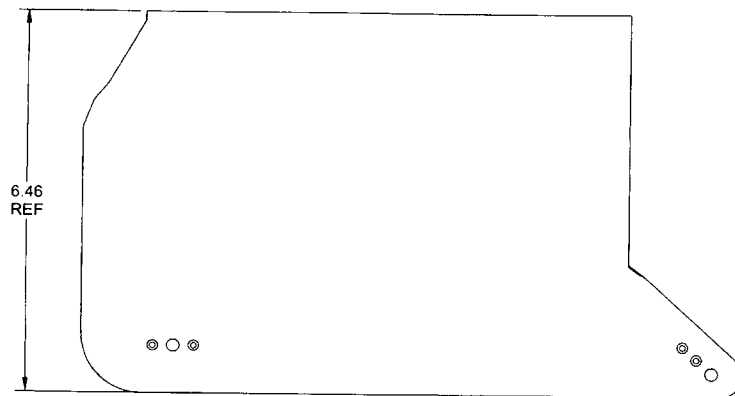
D4435-5F FLAT PATTERN

RELEASED
2012-03-02
JMD

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC. M6061T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	160	DRAWING NO. D4435	REV. 8
MFG. APPR.	EE	SHEET 7 OF 11	
APPROVED	160	TITLE	SCALE
DE APPR.	160	BRACKET	NTS
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83535

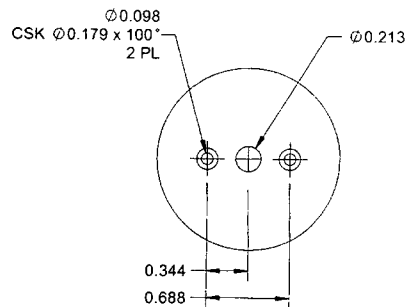
D4435-7 BRACKET

2012-03-02

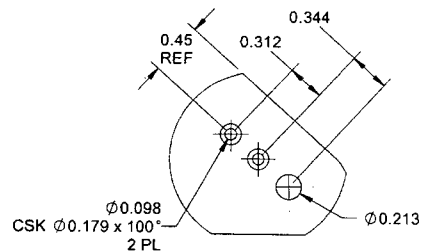
NOTES:

- 1) MATERIAL: MAKE FROM D4435-7F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.29 lbs

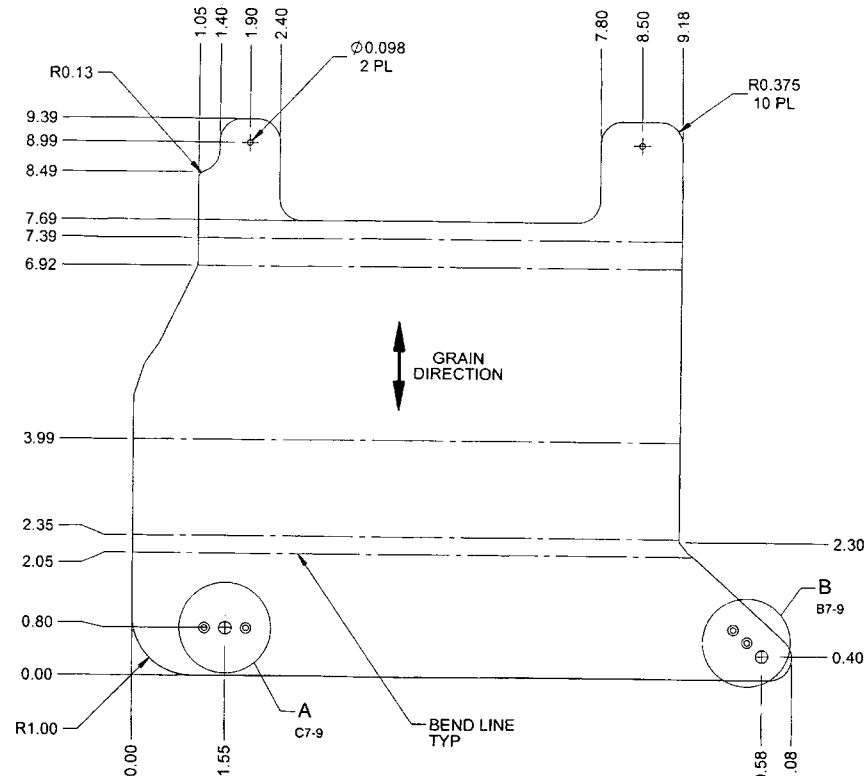
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4435	SHEET 8 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BRACKET	NTS
DATE	12.01.27	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



DETAIL A
SCALE 2X B5-9



DETAIL B
SCALE 2X B3-9



D4435-7F FLAT PATTERN

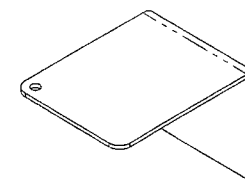
NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC. M6061T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.29 lbs

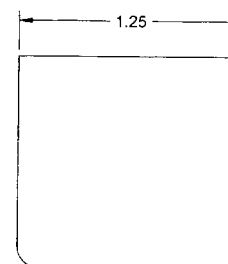
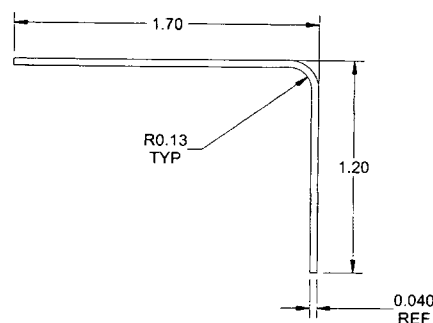
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4435	SHEET 9 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BRACKET	NTS
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2012-03-02
[Signature]

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D4435-9 BRACKET

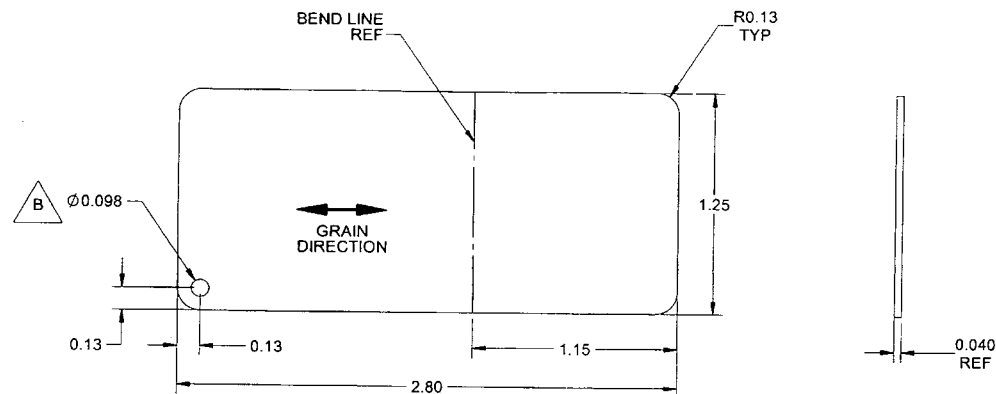
RELEASED
2012-03-02
JMD

NOTES:

- 1) MATERIAL: MAKE FROM D4435-9F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "BLACK SANDEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MD	DRAWING NO.	REV. B
MFG. APPR.	EE	D4435	SHEET 10 OF 11
APPROVED	MD	TITLE	SCALE
DE APPR.	JH	BRACKET	NTS
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D4435-9F FLAT PATTERN

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NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC. M6061T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	140	DRAWING NO.	REV. B
MFG. APPR.	E	D4435	SHEET 11 OF 11
APPROVED	140	TITLE	SCALE
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